

What is claimed is:

1. A manufacturing method for a frame body (12) that forms a metal frame body, comprising the steps of:

5 ring rolling a metal material to form a ring-shaped member (1);
forming a rectangular member (10) by pressing and deforming
the ring-shaped member (1) in radial directions; thereof
placing the rectangular member (10) in a mold, and;
pressing and die forging the rectangular member (10).

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2. A manufacturing method for a frame body (12) according to
claim 1, wherein when the rectangular member (10) is formed, the
angle (θ) of a corner portion (13) that imparts the rectangular shape
to the rectangular member (10) is made smaller than the angle (θ_1) in
15 the frame body (12) after die forging.

3. A manufacturing method for a frame body (12) according to
claim 1, wherein when forming the rectangular member (10), an insert
(6) is disposed inside the ring-shaped member (1).

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4. A manufacturing method for a frame body (12) according to
claim 2, wherein when forming the rectangular member (10), an insert
(6) is disposed inside the ring-shaped member (1).

25 5. A manufacturing method for a frame body (12) according to any

one of claims 1 through 4, wherein forming the height (A) of the ring-shaped member (1) in the axial direction at a height that is equivalent to a plurality of the frame bodies (12) when forming the ring-shaped member (1) ,

5 cutting the rectangular member (10) at a height (c) equivalent to the one frame body after forming the rectangular member (10) using this ring-shaped member (1), and die forging these frame bodies (12) separately.

10 6. A metal frame body (12) comprising wall portions (12a) and (12b), wherein grain flows (20) of the wall portions (12a) and (12b) run in longitudinal directions of the wall portions (12a) and (12b), respectively, and continue with each other.